

SUBSTITUTE ABSTRACT

A continuous-casting apparatus has a heating vessel holding a mass of molten metal having a surface level and provided below the level with a casting nozzle. A traveling mold has a pair of sides defining a downwardly extending passage having an upper end. An immersion tube extends from the casting nozzle down into the passage through the upper passage end and has an outer lower end below the upper end of the passage. The molten metal is made to flow from the vessel through the nozzle and through the tube into the passage for filling the passage with the metal to a level above the outer lower end of the immersion tube.